

Alh 345 058W

Work Order ID 68254



Monday, April 11, 2011 10:31:08 AM

Item ID:	D2617-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bushing					
Start Date:	4/11/2011	Start Qty:	30.00			
Required Date:	4/14/2011	Req'd Qty:	30.00			
Reference:						

Approvals:	Process Plan:		Date:	11/04/11	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2617	Rev D2								

100		0.00				33	0		
	Hardinge CNC LATHE SMALL								
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	Turn as per Folio FA437 and Dwg D2617								

11/5/11

110	QC2- Inspect parts off machine FA1/FA1B	0.00				33	0		
QC	Memo	0.00							
Quality Control									

11/5/11

120	QC8- Inspect parts - second check	0.00				33	0		
QC	Memo	0.00							
Quality Control									

B.A 11/05/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2617-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 4/11/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr break all unmarked sharp edges 0.005 to 0.010

11/5/11

33

P

140

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

33 BR 11-5-12

150

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

QC3
11/5/12

Pro 7

W/O: 68254		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/01/12	# 150	perm. change chang shp to QC3 inspecting	M-L	11/05/12 11.05.13	33X		S 11/05/12

Part No: D2617-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Item ID: D2617-3

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Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 4/11/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Packaging

Identify as per dwg & Stock Location: 19

0.00

Memo

0.00

Packaging

11/5/12 SP 33

170



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

11/5/12 [Signature]CMF
11-05-12

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Picklist Print

Monday, April 11, 2011 10:31:14 AM

Page 1

Work Order ID: 68254

Parent Item: D2617-3

Parent Item Name: Bushing



Start Date: 4/11/2011

Required Date: 4/14/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP ☐ G04.07.14 ☐ Reformat; added step 5 ☐ KJ/JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.058		Purchased	No			100	f	120.0000	0.0729	2.302105			
6061-T6 RD Tube .375 x.058W													

Location

Loc Qty

Loc Code

MAT014

120

115901

12

116920

108

117598

2.7 R1

SD 11/5/11

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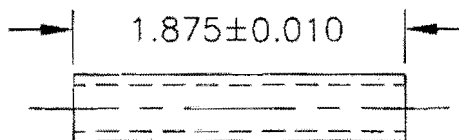
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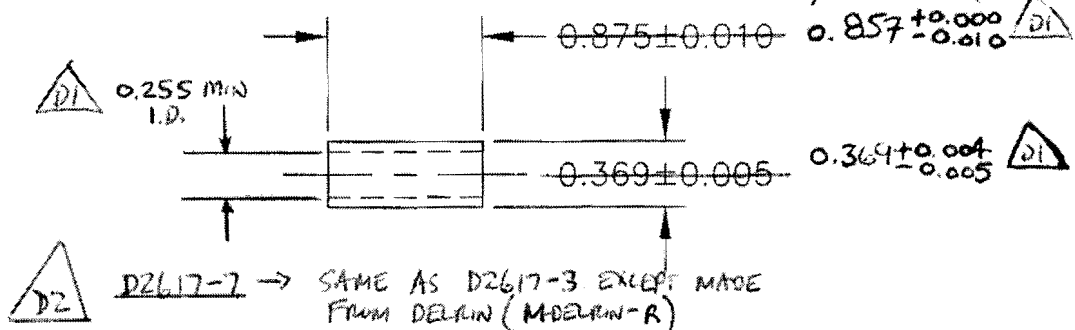
DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE	01.07.04			TITLE BUSHING	SCALE 1:1
DZ	04.04.10 #CP	ADD D2617-7		A	96.10.08 NEW ISSUE
				B	97.05.08 .875 WAS 1.125
				C	97.06.04 0.369 DIA WAS 0.375
				D	01.07.04 ADD MAT'L SPEC AND TOL./DIM. NOTE
				D1	04.07.12 CORRECT TOLERANCE (NCR 779)

D2617-1 (0.375 OD x 0.058 WALL)

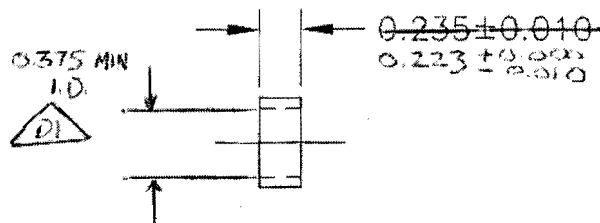


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68254
11104-4

D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05 #

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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